

Work Order ID 53071

Page 1

October 22, 2009 2:26:27 PM

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:



Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 11Date: 09-10-22 Tooling:

Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D130-780	B

100 0.00

DOCUMENT CONTROL

DC 0.00

Document Control Photocopy bluefile and type labels per PPP D130-780-044 CHG 001

BT 10-4-21

110 0.00

Pick Kit 0.00

BT 10-03-23

Packaging 0.00

Memo

Packaging

120 0.00

Small Fab 0.00

BT 10-04-05

Small Fab Memo

ASSEMBLE PER DWG D3186BT 09-10-22

Work Order ID 53071

October 22, 2009 2:26:27 PM

Page 2

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/05



QC

Quality Control

140

Pick Kit

0.00



Packaging

Memo

0.00

16-4-14

SF

150

QC4- 100% Inspect kits for completeness

0.00

S 10/04/05



QC

Memo

0.00

Quality Control

Work Order ID 53071

October 22, 2009 2:26:27 PM

Page 3

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Packaging

Memo

0.00

10-4-2054 R

Packaging

Identify and pack for shipping as per PPP D130-780-044

Location:

PPP Rev: A

170



QC21- Final Inspection - Work Order Release

0.00

10/04/21 H

QC

Memo

0.00

Quality Control

MF 10-4-21

Picklist Print

Page 1

October 22, 2009 2:26:31 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-4RevE 		Manufactured		No		110	Each	0.0000	1.0000		BT	10-04-01
Spacepod Door, RH							53085					
D2464-1250RevB 		Manufactured		No		110	Each	0.0000	1.0000		BT	10-04-01
Neoprene Seal 		Manufactured		No		110	Each	5.0000	1.0000		BT	10-03-23
Decal 												

			<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			Main Warehouse			
			ST	5		
			46233	5		X1
D2586RevD 	Manufactured	No		110	Each	107.0000 2.0000
Door Latch 						

			<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			Main Warehouse			
			ST	107		
			23082	0		
			45554	1		
			47183	6		
			50213	100		

Picklist Print

Page 2

October 22, 2009 2:26:31 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2585RevB



Mounting Channel

Manufactured

No

110

Each

47.0000

2.0000



BT 10-03-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

Loc Qty

4

B53798

45888

4

Main Warehouse

ST37

Loc Qty

43

50544

4

51526

39

D2621RevB



Latch Plate, 350 Spacepod

Manufactured

No

110

Each

68.0000

2.0000



BT 10-03-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

Loc Qty

68

46842

68

X2

Picklist Print

October 22, 2009 2:26:31 PM

Page 3

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	---------------------	---------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

MS27039-1-15



Screw

Purchased

No

110

Each

180.0000

2.0000



BT 10-03-23

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

180

106903

3

108169

4

109321

4

111916

69

112794

100

x2

NAS1149D0363J



Washer

Purchased

No

110

Each

2.0000

2.0000



BT 10-03-23

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

2

112314

2

M113288 +2

Picklist Print

Page 4

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3



Purchased

No

110

Each

3,430.000 2.0000



Nut

BT 10-03-23

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

MS21042L3

D2857-1RevB



Manufactured

No

110

Each

18.0000 1.0000



Hinge Bracket

BT 10-03-23

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

18

41166

7

45788

5

50235

6

B55019

Picklist Print

Page 5

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2857-2RevB

Manufactured

No

110

Each

14.0000

1.0000



BT 10-03-23

Hinge Bracket

Warehouse
Location

Loc Qty

Loc Code

355020

Main Warehouse

ST

14

45797

14

D2228RevB

Manufactured

No

110

Each

80.0000

2.0000



BT 10-03-23

Bracket Plate

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

80

30679

37

48228

43

TAN526C832R10

Purchased

No

110

Each

105.0000

10.0000



BT 10-03-23

Screw

Warehouse
Location

Loc Qty

Loc Code

B

Main Warehouse

ST

105

104603

105

X 60

Picklist Print

Page 6

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J

Purchased

No

110

Each

375.0000

12.0000

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 375

111193 3

111359 72

112385 300

m 114108 x12

MS21042L08

Purchased

No

110

Each

407.0000

12.0000

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 407

110002 24

111889 51

112243 47

112492 85

112612 100

112794 100

m 113749 x12

Picklist Print

Page 7

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3557-1RevA



Manufactured

No

110

Each

23.0000

1.0000



Bracket

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

23

32647

1

46887

7

50283

15

D3554-7RevA



Manufactured

No

110

Each

60.0000

1.0000



Ball Stud

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

60

37674

60

NAS1149D0563J



Purchased

No

110

Each

100.0000

1.0000



Washer

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

100

112794

100

M113724

Picklist Print

Page 8

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3015-3RevB		Manufactured	No		110	Each	328.0000	1.0000				
-------------	--	--------------	----	--	-----	------	----------	--------	--	--	--	--

Locknut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	128	
----	-----	--

43758

26

44446

49

48238

53

Main Warehouse

ST59	200	
------	-----	--

51711

200

AN526C832R14

Purchased	No		110	Each	937.0000	2.0000		
-----------	----	--	-----	------	----------	--------	--	--

Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	937	
----	-----	--

104916

937

Picklist Print

Page 10

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J

Purchased

No

140

Each

375.0000

4.0000



M114340

10-4-14 SP

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

375

111193

3

111359

72

112385

300

NAS1515H3

Purchased

No

140

Each

490.0000

2.0000



10-4-14

SP

Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

490

109268

259

110397

87

111268

144

2

Picklist Print

Page 11

October 22, 2009 2:26:32 PM

Work Order ID: 53071



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08 		Purchased		No		140	Each	407.0000	2.0000			<i>M114056 10-4-14</i>

Nut

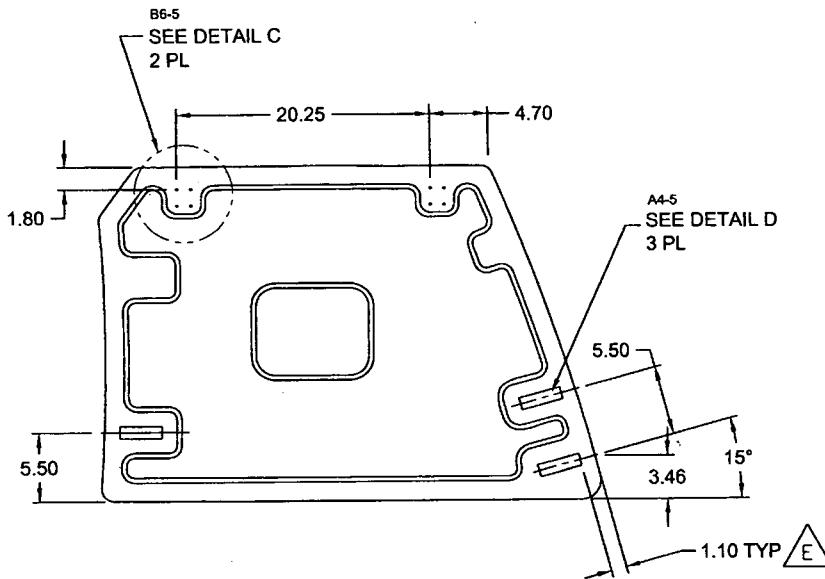
Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	407	
110002	24	
111889	51	
112243	47	
112492	85	
112612	100	
112794	100	

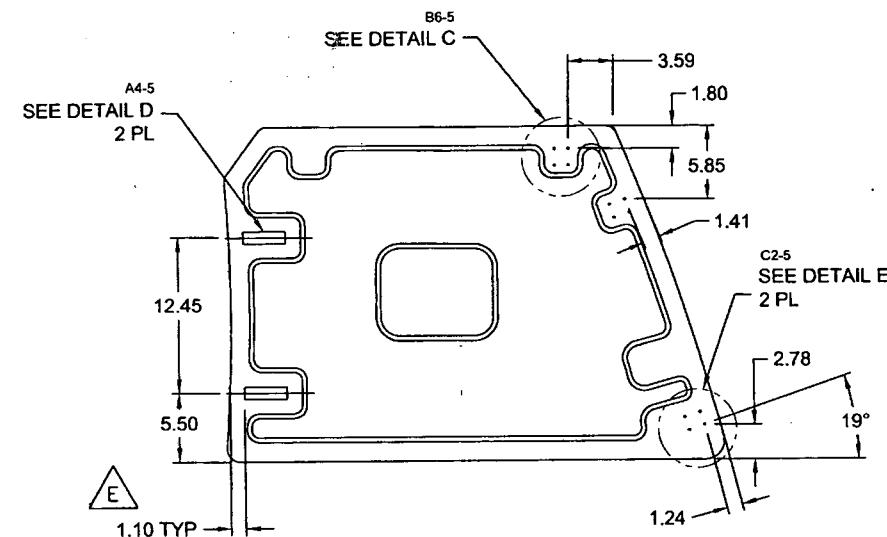
8 7 6 5 4 3 2 1



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2008-09-09

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 53071
Blg 10-22

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026		RF	09.07.08
D	UPDATE DIMENSIONS		LE	07.02.22
C	REMOVED D0600-XXX LABELS		LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M-2M-3/4 ADDED		LE	06.09.25
A	NEW ISSUE		CP	03.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO. <u>D3186</u>		
CHECKED	<i>10</i>	REV. E		
MFG. APPR.	<i>NA</i>	SHEET 1 OF 5		
APPROVED	<i>NA</i>	TITLE <u>SPACEPOD DOOR</u>		
DE APPR.	<i>NA</i>	SCALE <u>NTS</u>		
DATE	<u>09.07.08</u>	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER THE TERMS AND CONDITIONS THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

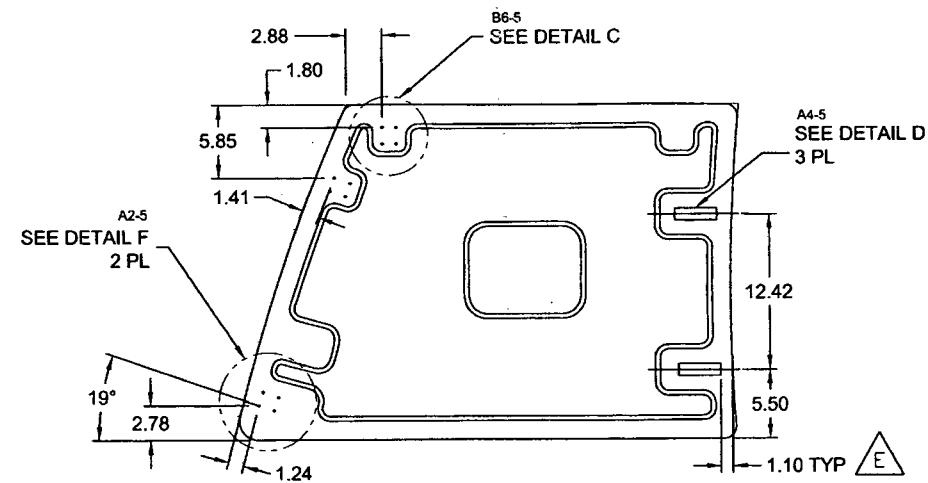
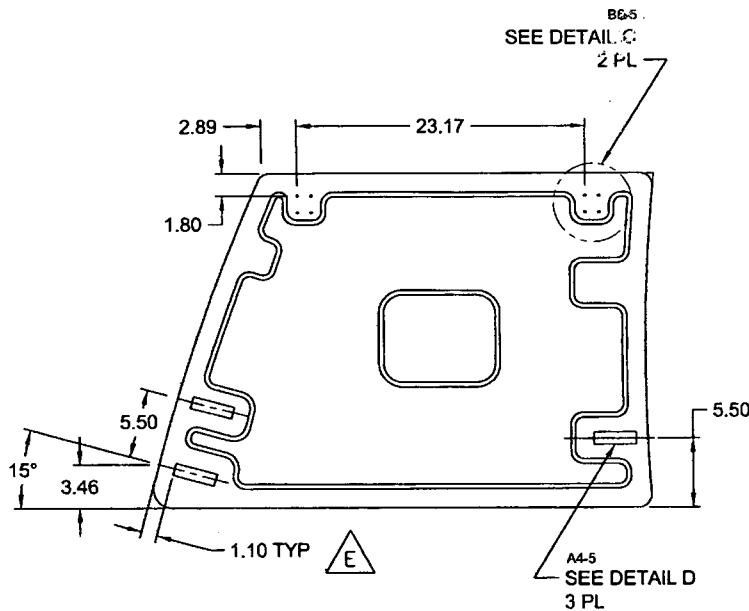
53071

D

C

B

A



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

NOTES:

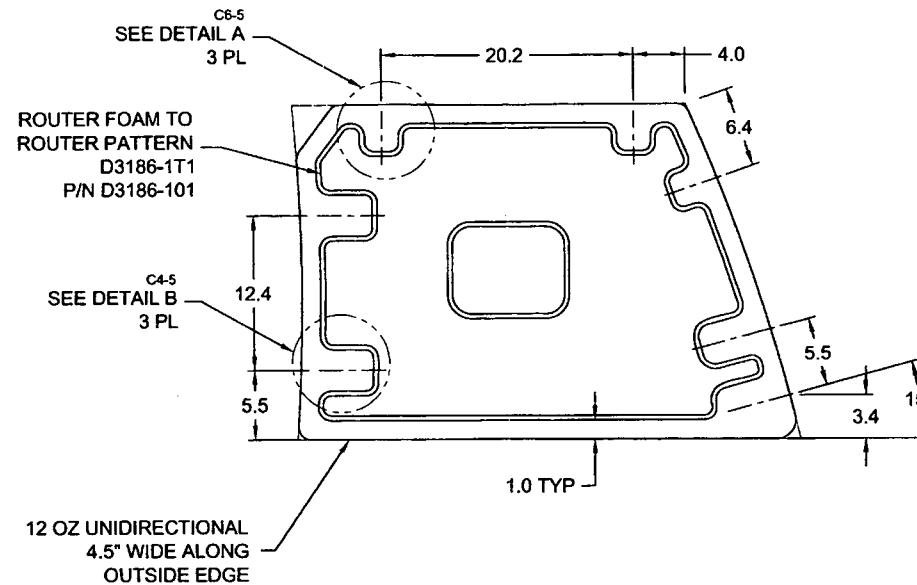
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JK</i>	DRAWING NO. REV. E	
MFG. APPR.	<i>MD</i>	D3186 SHEET 2 OF 5	
APPROVED	<i>MD</i>	TITLE SCALE	
DE APPR.	<i>JK</i>	SPACEPOD DOOR NTS	
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

53071



MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) MATERIAL:
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8005 FOR DOOR LAYUP

RELEASED
 2009-08-08
WT

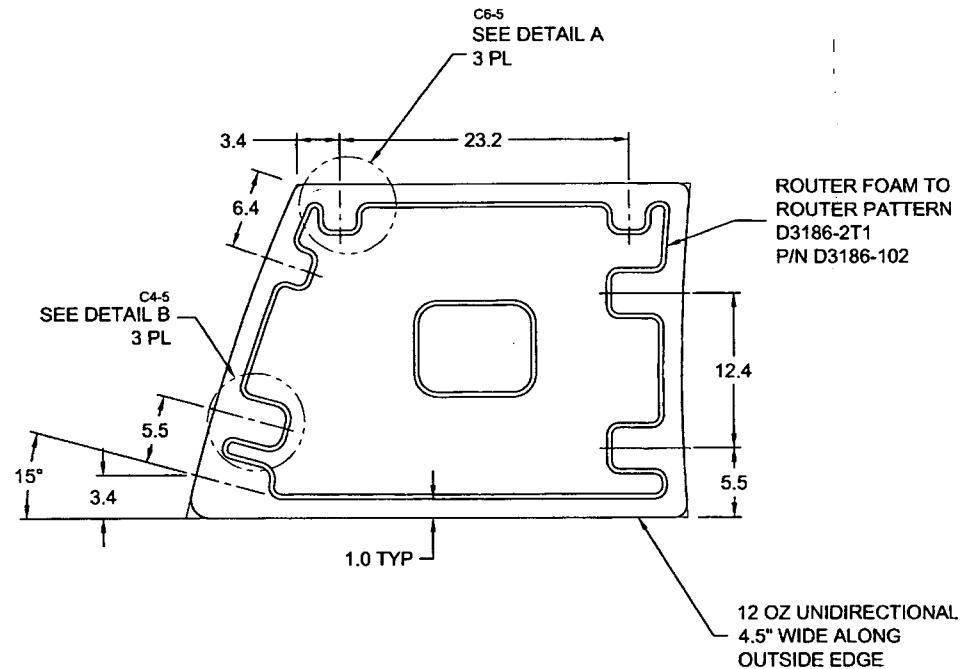
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>WT</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>WT</i>	D3186	SHEET 3 OF 5
APPROVED	<i>WT</i>	TITLE	SCALE
DE APPR.	<i>WT</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

53071



NOTES:

- 1) MATERIAL:
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

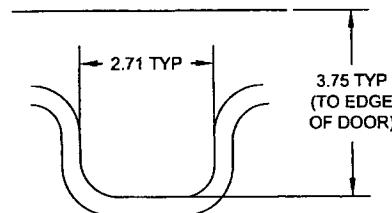
D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2009-08-09
[Signature]

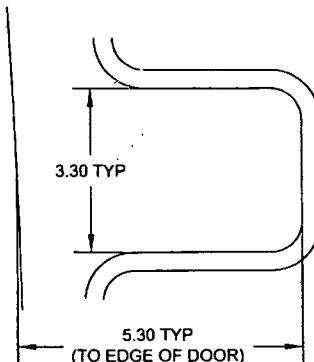
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

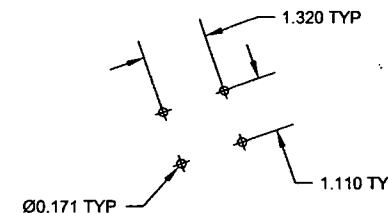
53071



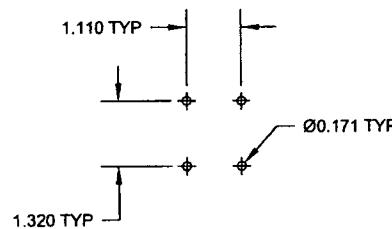
DETAIL A D6-3
SCALE 4X D4-4



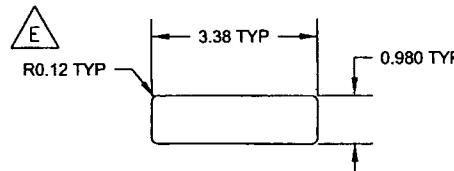
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

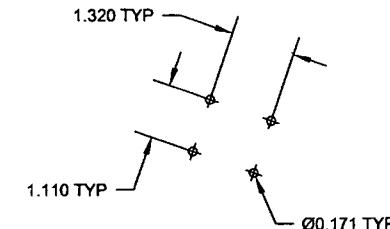


DETAIL C D7-1
D3-1
D6-2
D3-2
SCALE 4X



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

8 7 6 5 4 3 2 1

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.		D3186 SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D130-780

Page 32 of 34

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
↑	1						D3837-1	DECAL
↓	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

• COPYRIGHT © 2008 BY DART AEROSPACE LTD.
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B
 Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IN-D130-780

Page 33 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
					1*	1*		NEOPRENE SEAL
1**							D3837-3	DECAL
1**							D3837-4	DECAL
					2*	2*		LATCH
					2*	2*		MOUNTING CHANNEL
					2*	2*		LATCH PLATE
					2*	2*		SCREW
					2*	2*		WASHER
					2*	2*		MS21042L3
								NUT (or MS21042-3)
					1*	1*		HINGE BRACKET
					1*	1*		HINGE BRACKET
					2*	2*		BACKING PLATE
					8*	8*		AN526C832R10
					8*	8*		SCREW
					8*	8*		NAS1149DN832J
								WASHER
								MS21042L08
								NUT
					1*	1*		BRACKET
					2*	2*		BACKING PLATE
					1*	1*		BALL STUD
					1*	1*		WASHER
					1*	1*		LOCK NUT
					2*	2*		AN526C832R14
					2*	2*		SCREW
					4*	4*		AN526C832R10
					4*	4*		SCREW
								NAS1149DN832J
								WASHER
								MS21042L08
								NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
					1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
					1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
					2***		D3518-3	ROD END

• COPYRIGHT © 2008 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B
Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D130-780

Page 34 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
					1		D3983-1	OUTER CLOSEOUT
					1		D3983-3	INNER CLOSEOUT
					1		D3983-5	HINGE CLOSEOUT
					1		D3983-047	CLOSEOUT ATTACHMENT
					1		D3983-9	SPACER
					2		AN525-10R6	SCREW
					1		AN525-10R24	SCREW
					1		NAS1149D0363J	WASHER
					1		MS21042L3	NUT

* Pre-installed on D3186-3/4 Spacepod™ Door

** Pre-installed on D3188-5/6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

• COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B
Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY
REF. EASA.I.M.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-13	DOOR PROP

WAS	-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
					1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.02.03
CERT. NO.:	SH93-88
ISSUE NO.:	6

A	NEW ISSUE		10.02.03
REV.	DESCRIPTION		BY DATE
DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AS</i>		
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9502	
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	REPLACEMENT DOOR PROP NTS	
DATE	10.02.03		

COPYRIGHT © 2010 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries